

Work Order ID 63553

Thursday, November 04, 2010 10:03:36 AM



Page 1

Item ID: D3278-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Assembly

Start Date: 11/4/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-11-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Rivet spacers with support as per Dwg D3278.

8/5/11/01/10 (40)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/16/10

counted (40)

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble support as per Dwg D3278. ***DO NOT TIGHTEN BOLTS*** Identify as D3278-041

8/5/11/01/10 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Thursday, November 04, 2010 10:03:40 AM

Page 1

Work Order ID: 63553

Parent Item: D3278-041

Parent Item Name: Support Assembly



Start Date: 11/4/2010

Required Date: 11/19/2010




Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1  Support		Manufactured	No			100	Each	11.0000	1	40			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST045			4						
				60564			4						
				ST048			7						
				51353			7						
D3278-2  Support		Manufactured	No			100	Each	9.0000	1	40			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST048			9						
				60565			9						
D3278-3  Spacer		Manufactured	No			100	Each	74.0000	1	40			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST045			74						
				60244			74						

ES 11/01/10
B62482 (36x)

ES 11/01/10
B62483 (33x)

ES 11/01/10
40

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Thursday, November 04, 2010 10:03:40 AM

Page 2

Work Order ID: 63553

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 11/4/2010

Required Date: 11/19/2010

Start Qty: 40.00

Required Qty: 40.00

MS21042L4

Purchased

No

100

Each

2,779.000

2

80



Nut

Location

Loc Qty

Loc Code

ST300

2779

113422

25

114523

8

115589

1646

115621

1100

AN4-13A

Purchased

No

120

Each

413.0000

2

80



Bolt

Location

Loc Qty

Loc Code

ST357

300

115936

300

ST358

113

115159

113

AN960JD416

NAS1149D0463J

Purchased

No

120

Each

24.0000

4

160



Washer

LD M114742 (160x)

Location

Loc Qty

Loc Code

ST300

24

113288

24

D2230-1

Manufactured

No

120

Each

17.0000

2

80



Lug

Location

Loc Qty

Loc Code

ST430

14

62665

14

ST476

3

61713

3

Thursday, November 04, 2010 10:03:40 AM

Shop Packet Print

Page 2

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Thursday, November 04, 2010 10:03:40 AM

Page 3

Work Order ID: 63553

Parent Item: D3278-041

Parent Item Name: Support Assembly



Start Date: 11/4/2010

Required Date: 11/19/2010

Start Qty: 40.00

Required Qty: 40.00

MS20426AD3-6

Purchased

No

120

Each

1,330.000

4

160



Rivet



Handwritten signature and date: 11/01/10

160

Location

Loc Qty

Loc Code

ST316

1330

105055

1330

W/O:		WORK ORDER CHANGES					
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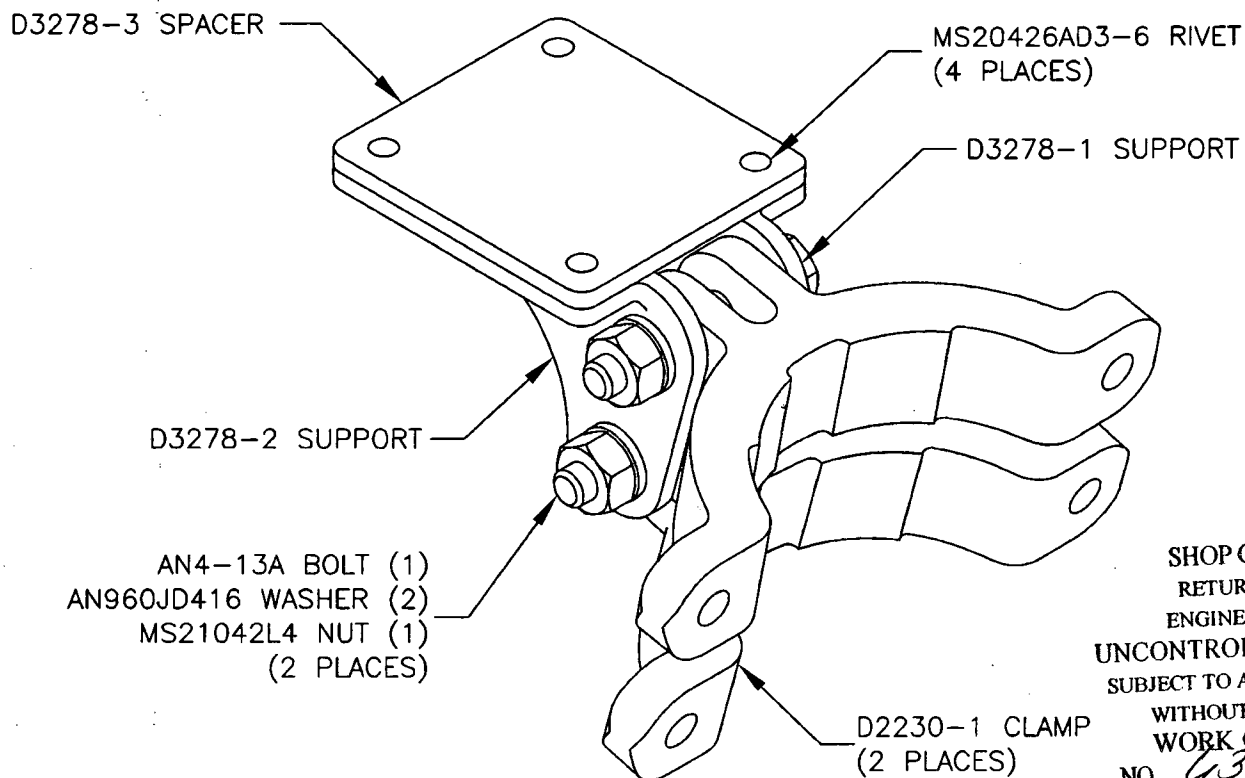
NOTE: Date & initial all entries

DART

DESIGN <i>97</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *63553*
BS10-11-09

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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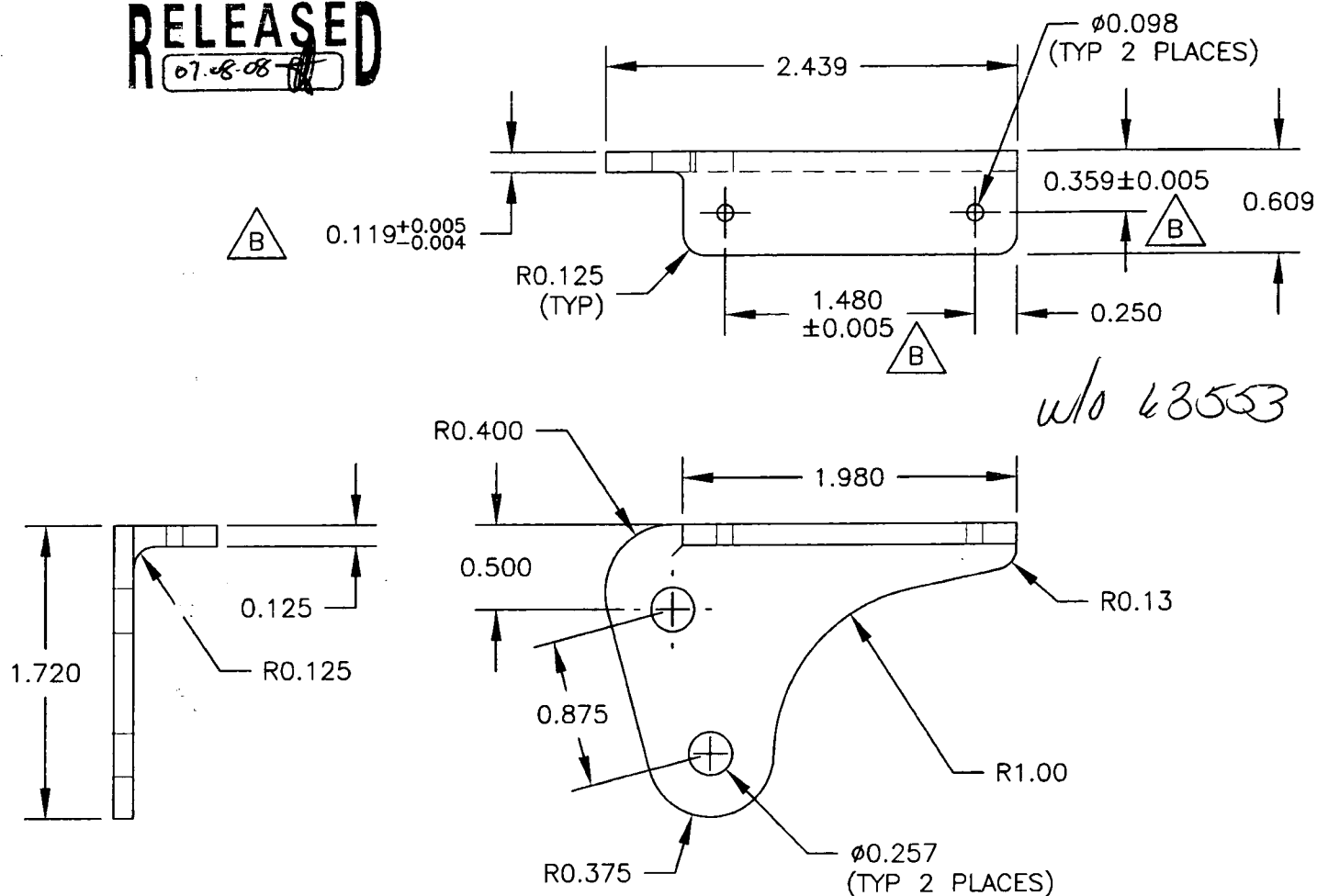
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DESIGN <i>9P</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-08-08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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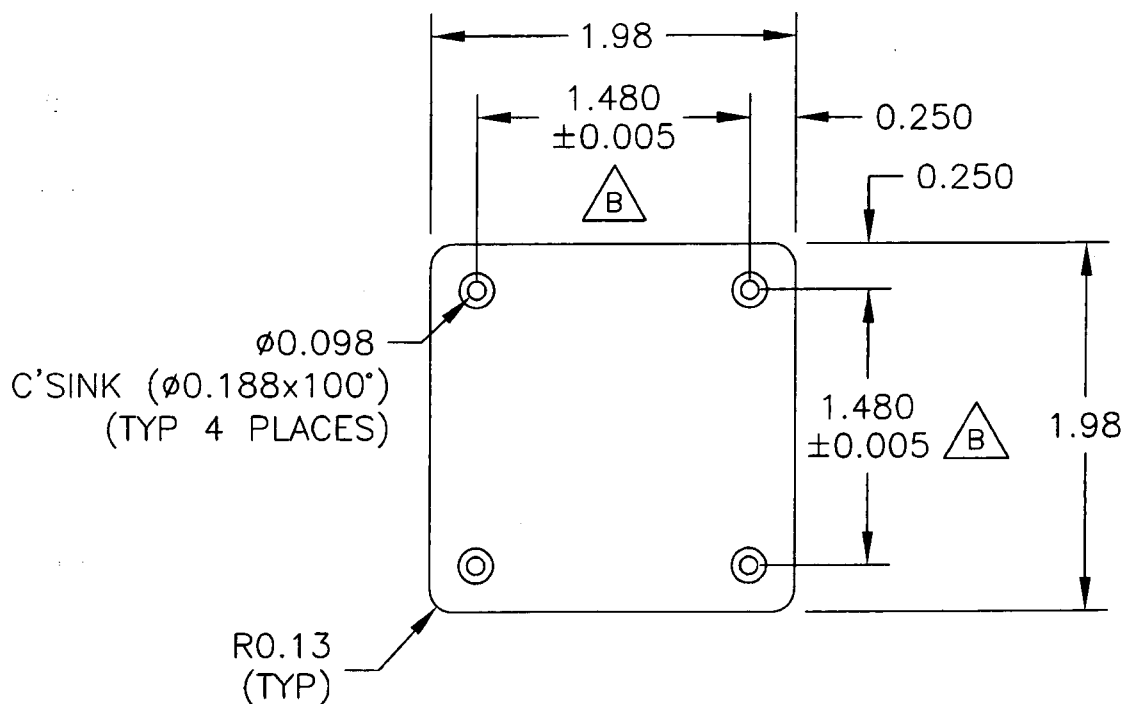
NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08

w/b 43553



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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